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D4753-1

Job Sheet 199934



Part No: D4753-1

Job Qty: 50 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	50 pcs		9/18/19	0.17	1.50	Waterjet - Flow		DC 19/07/18
110	QC 2	50 pcs		9/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DC 19/09/18
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120 HAAS 5 Axis - B4B	50 pcs	9/18/19	0.75 3.60	HAAS - 5 - B4B	Kt 19.09.23
140 QC 8	50 pcs	9/18/19	0.00 0.00	QC 8 - 12	Sm 19/09/24
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Small Fab - 2 - B4B	50 pcs	9/18/19	0.00 0.59	Small Fab - 1 - B4B	DAS 58 SEP 26 2019
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
160 QC 5	50 pcs	9/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 SEP 27 2019
				QC 5 - 61	9-89
				QC 5 - 81	

170 Handfinish - 1-1 Chemical-B4B	50 pcs	9/18/19	0.00 0.42	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	50 pcs	9/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	

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DAS
81
9-89

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190 Packaging 3-1 - Stock - B4B	50 pcs	9/18/19	0.00 0.00	QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	50 pcs	9/18/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-59

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Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A ***.758" DIA HOLE TO BE OPENED TO FIN

Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Deburr if necessary

110 - QC2- Inspect parts off machine FAI/FAIB

120 - HAAS CNC Vertical Machine - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: AA DWG

REV: A ***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**

140 - QC8- Inspect parts - second check

150 - C'sink as per Dwg D4753 (On Flat side)

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1

180 - QC7-Inspect Chemical Conversion Coat

190 - Identify as per dwg & Stock Location: LOCATION : LG001

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.6900 sf (.0138 ea)	100-Waterjet - Flow - 1	S/1629837

Job Allocations				
Operation 100-Waterjet - Flow - 1	Component Part M6061T6S.125	Required 1	Inventory 21	Allocated 0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	Diameter
2	Doubler	0.500Inches ± 0.010	0.510 0.490	.129 .502
3	Doubler	1.000Inches ± 0.010	1.010 0.990	1.006
4	Doubler	0.750Inches ± 0.010	0.760 0.740	.753
5	Doubler	1.500Inches ± 0.010	1.510 1.490	1.505
6	Doubler	2.000Inches ± 0.010	2.010 1.990	1.997
7	Doubler	0.126Inches ± 0.010	0.136 0.116	.122
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	Diameter 3.540
9	Doubler	0.126Inches ± 0.010	0.136 0.116	.122

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Part No. _____					
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
Completed By		MRB (QSI042)			
Lead hand / Supervisor					
QC / QA Coordinator					
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				